

Work Order ID 91705***91705***

Page 1

October-15-12 3:24:07 PM

Item ID: D3186-2M

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: SPACEPOD DOOR RH

Start Date: 10/15/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/05/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3186

Rev E

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 18135

Description: D3186-2MDoor

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

12-10-1610/15/12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 91705

91705

Page 2

October-15-12 3:24:07 PM

Item ID: D3186-2M Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: SPACEPOD DOOR RH
 Start Date: 10/15/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/05/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo Check for void spot and pins.	0.00 0.00		DAS 16 13/1/30					
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>composites</u> Memo	0.00 0.00							RT 13-01-31 (x1)
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/1/31 (x1) MCS 13-01-31

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Picklist Print

October-15-12 3:24:07 PM

Page 1

Work Order ID: 91705

Parent Item: D3186-2M

Start Date: 10/15/12

Required Date: 11/05/12

Parent Item Name: SPACEPOD DOOR RH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2P Spacepod Door		Purchased	No			110	Each	0.0000	1	1			

B 91705

13-01-31

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Supplier <input type="checkbox"/>											
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FAULT CATEGORY											
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8 7 6 5 4 3 2 1

D

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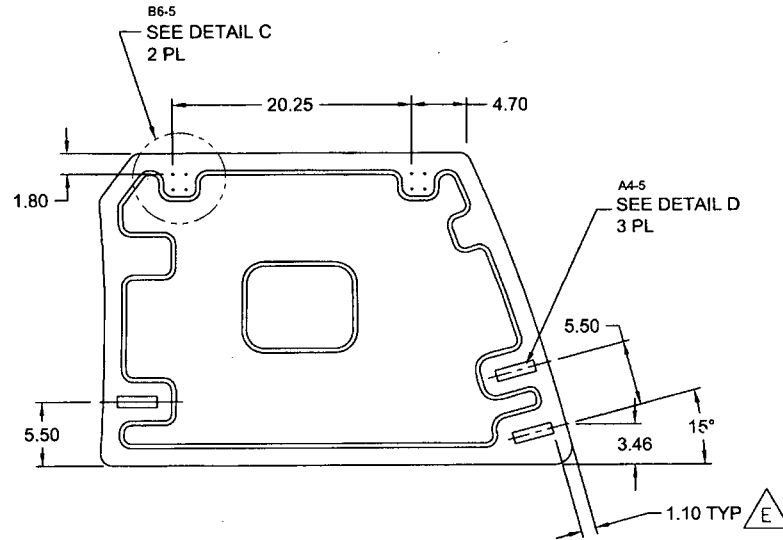
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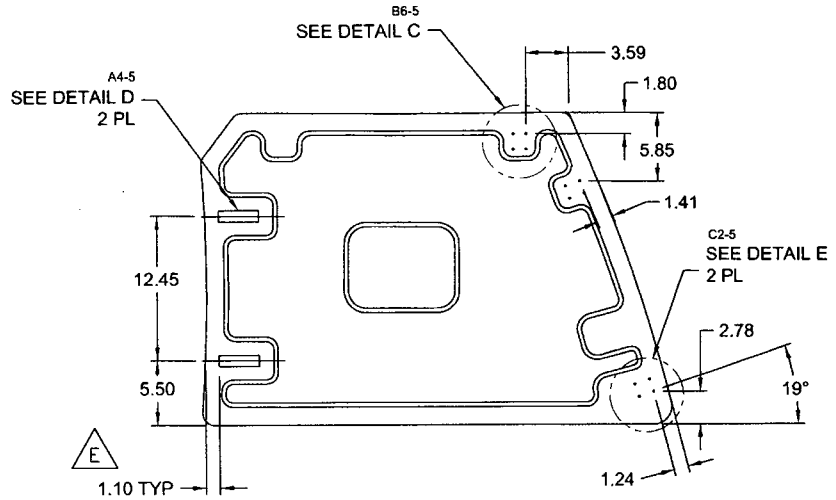
A

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D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

w/b 92703

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/2M/3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

8 7 6 5 4 3 2 1

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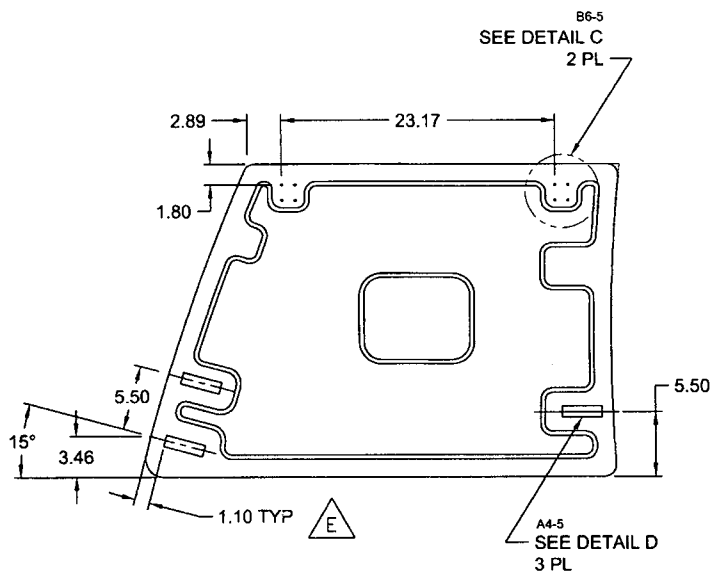
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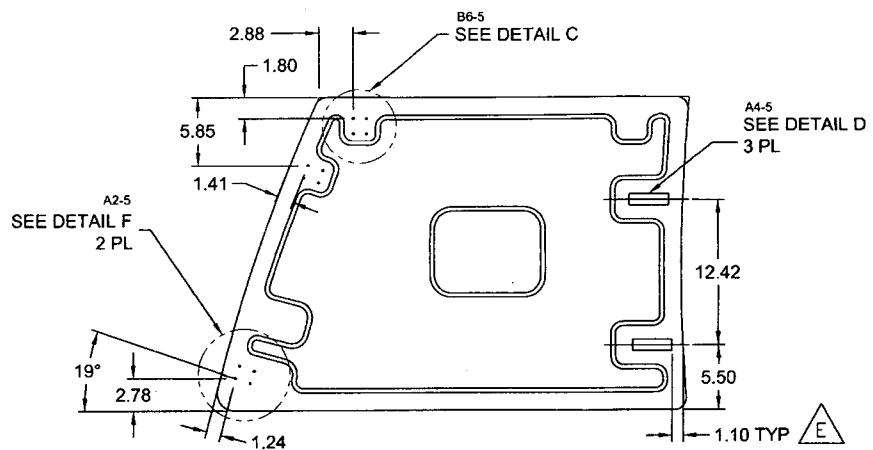
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D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M







D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2008-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

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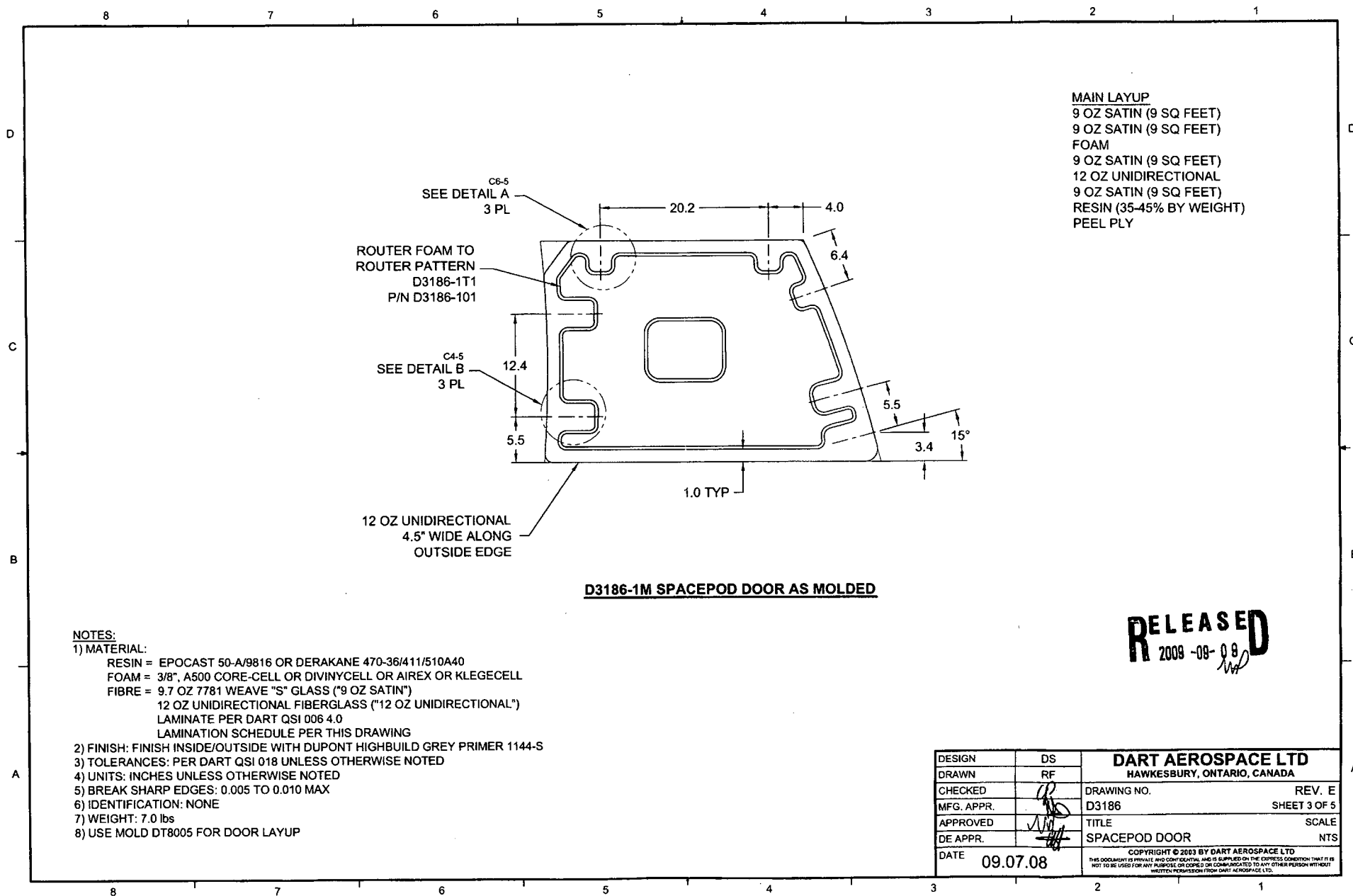
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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NCR: Yes / No

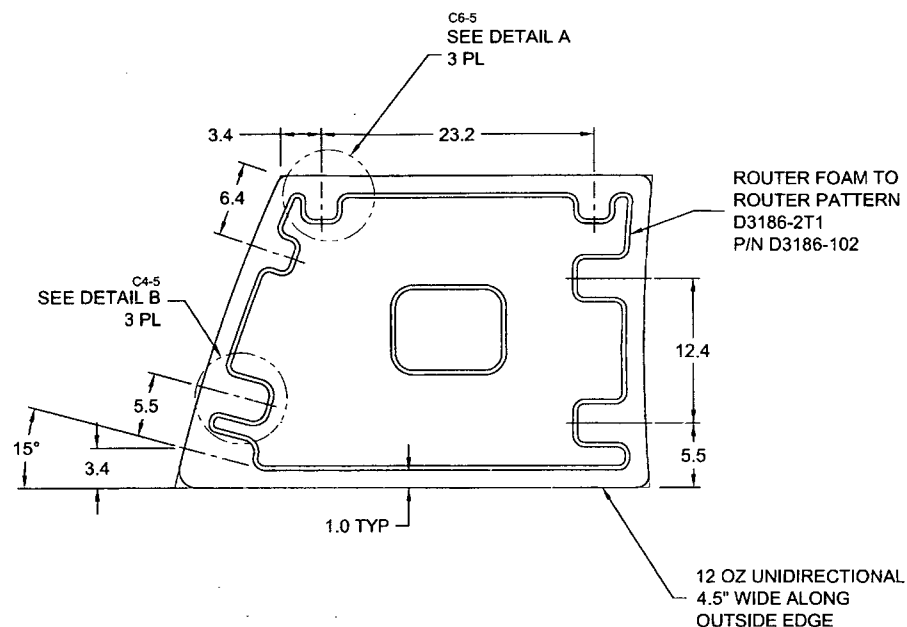
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Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											
FAULT CATEGORY																											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other																

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0

LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED





5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3186	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NT
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD. THE DESIGN IS HEREBY RELEASED BY THE EXPRESS PERMISSION THAT IT NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

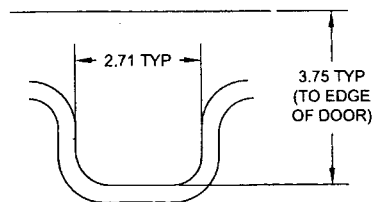
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

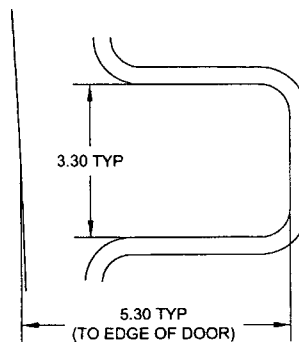
DQA: _____ Date: _____

QA Closed: _____ Date: _____

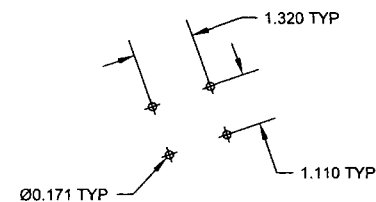
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		



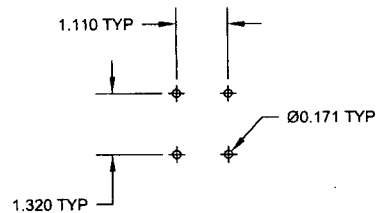
DETAIL A D6-3
SCALE 4X D4-4



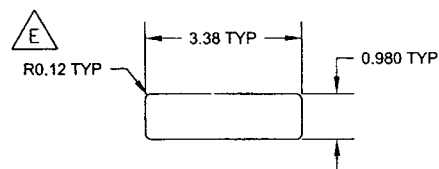
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

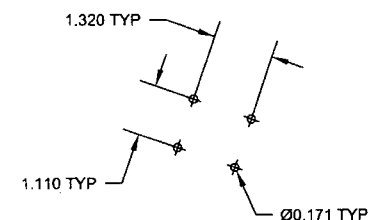


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		



DELASTEK Inc.
2699 5e Avenue
Local 14, C.P. 10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	46495
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle



Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
21-01-2013	16-10-2012	21923	Brigitte Golden	PO18135	Net 30 days USA
Ship Via	F.O.B.		Salesperson		GST/PST
Day & Ross Collect	Origin		Mathieu Veilleux, ext. 235		
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0071	Line #1 N° D3188-2P, Spacepod Body RH B917(U of M: Chaque Dwg. D3188 Rév.: F Serial # Lot # B91701 45778	
1	0	1	DKC134-0060	Line #4 N° D3186-2P Spacepod Door RH B9170 U of M: Chaque Dwg. D3186 Rév.: E Serial # Lot # B91705 47607 8.31.130	

21 JAN. 2013

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☒ Ship.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18135**

Purchase Order Date 10/16/2012

PO Print Date 10/16/2012

Page Number 1 of 2

Order From :

VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

819 533 5788

819 533 3494

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Brigitte Golden

10127-2607

Net 30

USD

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3188-2P	Spacepod Body	12/7/2012 No	1.00 Each	Day & Ross coll	\$2,177.0000	\$2,177.00
		Special Inst:	AS PER DWG: D3188, REV: F B91701				
2	D3186-2P	Spacepod Door	12/7/2012 Yes	1.00 Each	Day & Ross coll	\$711.0000	\$711.00
		Special Inst:	AS PER DWG: D3186, REV: E B91704				
3	D3188-2P	Spacepod Body	12/7/2012 Yes	1.00 Each	Day & Ross coll	\$2,177.0000	\$2,177.00
		Special Inst:	AS PER DWG: D3188, REV: F B91703				
4	D3186-2P	Spacepod Door	12/7/2012 Yes	1.00 Each	Day & Ross coll	\$711.0000	\$711.00

PO Instructions:

DAY&ROSS ACCT # 038326

**CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY**

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Change Nbr:

Change Date: 10/16/2012



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18135**

Purchase Order Date 10/16/2012

PO Print Date 10/16/2012

Page Number 2 of 2

Order From :

VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

819 533 5788

819 533 3494

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Brigitte Golden

10127-2607

Net 30

USD

Destination-Collect

Special Inst: AS PER DWG: D3186, REV: E
B91705

PO Total:

\$5,776.00

D 2213 v14 B 30809

Ref: P018135

Dep:

Date: 16Oct12

Wgt: 1.00 LBS

DV:

SHIPPING:

SPECIAL:

HANDLING:

TOTAL:

19.90

4.23

0.00

24.13

Sves: PRIORITY OVERNIGHT
TRCK: 9018 2264 5065

PO Instructions:

DAY&ROSS ACCT # 038326

Change Nbr:

1

Change Date: 10/16/2012

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO

Date: Lundi, 2012-12-17 11:18:46
Utilisateur: marc dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE	Nom Dessin	: SPACEPOD DOOR RH
Numéro Job	: 47607	Numéro Article	: DKC134-0060
Numéro	: 3769	Numéro Dessin	: -
Numéro B.A.		Projet Numéro	: DK-362
Cette fois	: 2012-12-17 No. :	Révision dessin	:
Prsht Rev.	: NC	Matériel	: 7781 & 411-350
Prem. fois	: - - Type :	Date Dûe	: 2012-12-24 Qté: 1 Ud UNITE
Job précédente	: 45777		
Écrit par	: _____		
Vérifié & Approuvé par	: _____		
Commentaires	: N° de dessin: D3186-2M rev. E		

E.O.: N/A

Feuille de Procédé Rév.: 03 AMB0349 remplacé par
AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

B 91705

Produit additionnel

Numéro Job:



Séq.:

Machine ou

Description :

1.0

AAC1616

N° 83634, Frekote Loctite Wolo

Comment

Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
N° 83634, Frekote Loctite Wolo N° de Lot: 1-37420-1

2.0

PRÉPARATION

Préparation du moule



Comment

Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009.

Date: 18/12/12 Sceau:

3.0

AAC1885

Tissu à délaminer Release ply B

Comment

Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B # de Lot: N/A

4.0

AAC1887

Wrighton 5200 Bleu P3

Comment

Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrighton 5200 Bleu P3 # de Lot: N/A

5.0

AC0885




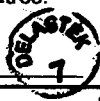




Feutre de drainage N° Airweave N 10

Comment

Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)













Date: Lundi 2012-12-17 11:18:46
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR RH
Numéro Job:	47607		Numéro	DKC134-0060
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
6.0	AC0943	Stretchlon 200 poche à vide Vert		
Comment	Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)			
7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish		
Comment	Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: <u>1-36539-2</u>			
8.0	AC0886	Ruban à gommer jaune #: T/AT-200Y		
Comment	Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)			
9.0	AMB0511	N° TG-13-U, Fiberglass 13 oz		
Comment	Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s) N° TG-13-U, Fiberglass 13 oz N° de Lot: <u>1-36302-1</u>			
10.0	PREP-GENERAL	Préparation du matériel		
				
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs Tailler le matériel selon les différents patrons de découpe. Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide. Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres. Date: <u>17/12/12</u> Sceau: 			
11.0	AMB0286	Catalyst N° DDM-9		
Comment	Qty.: 0.0080 GALLON(s)/Unit Total : 0.0080 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
12.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.		
Comment	Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-38897-1</u>			
13.0	PREP-GENERAL	Préparation du matériel		
				
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine. Date: <u>18/12/12</u> Sceau:  			

Date: Lundi, 2012-12-17 11:18:46
Utilisateur: marc dubé










Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR RH
Numéro Job:	47607		Numéro	DKC134-0060
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
14.0	LAMINAGE	Faire le laminage		
				
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz. Date: <u>8/12/12</u> Sceau:  			
15.0	BAGGING	Faire le bagging sur la pièce		
				
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs Faire la poche à vide selon IG 0012. Laisser sécher pendant 4 heures minimum. Heure début Curing: <u>3:45</u> Heure Fin Curing: <u>8:00</u> Date: <u>8/12/12</u> sceau:  			
16.0	AMB0286	Catalyst N° DDM-9		
Comment	Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
17.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.		
Comment	Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s) Résine (411B7530) 411-350 promo. 75min N° de Lot: <u>1-38597-1</u>			
18.0	PREP-GENERAL	Préparation du matériel		
				
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core selon IG0105. Date: <u>21/12/12</u> Sceau: 			
19.0	DKC134-0057	Foam Core N° D3186-102 (Porte D3186-2)		
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D3186-102 (Porte D3186-2) N° de Job: <u>47711</u>			

Date: Lundi, 2012-12-17 11:18:46

Utilisateur: marc dubé
















Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR RH
Numéro Job:	47607		Numéro	DKC134-0060
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
20.0	AAC1611	Polybond B46F		
Comment	Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s) Polybond B46F N° de Lot: <u>1-29934-1</u>			
21.0	ASSEMBLAGE	Assemblage mécanique		
				
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs Retirez le bagging. Pour aider au positionnement de 13 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage. Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.) Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet. Date: <u>27/12/12</u> Sceau:  			
22.0	BAGGING	Faire le bagging sur la pièce		
				
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs Faire la poche à vide selon IG 0012. Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure début Curing: <u>9:10</u> Heure Fin Curing: <u>10:20</u> Date: <u>27/12/12</u> Sceau:  			
23.0	AMB0286	Catalyst N° DDM-9		
Comment	Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
24.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.		
Comment	Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s) Résine (411B7530) 411-350 promo. 75min N° de Lot: <u>1-38897-1</u>			

Date: Lundi, 2012-12-17 11:18:46

Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	SPACEPOD DOOR RH
Numéro Job:	47607		Numéro	DKC134-0060
Numéro Job:				
# Séq.:	Machine ou Opération:	Description :		
25.0	PREP-GENERAL 	Préparation du matériel 		
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine. Date: <u>28/12/12</u> Sceau:  			
26.0	LAMINAGE 	Faire le laminage 		
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs Faire le laminage d'un pli de 9.7 oz. Faire le laminage d'un pli de 13 oz. tout le tour de la porte. Faire le laminage d'un pli de 9.7 oz. Date: <u>28/12/12</u> Sceau:  			
27.0	BAGGING 	Faire le bagging sur la pièce 		
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs Faire la poche à vide selon IG 0012. Laissez Sécher 4 heures minimum Heure début Curing: <u>8:00</u> Heure Fin Curing: <u>4:00</u> Date: <u>28/12/12</u> Sceau:  			
28.0	DÉMOULAGE 	Démoulage de la pièce 		
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Démouler la pièce en faisant bien attention aux coins & Edges. Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci. Date: <u>20/1/13</u> Sceau: 